me in the

Work Order ID 48090A

F

June 29, 2009 2:37:24 PM

Required Date: 03/08/2009

Item ID:

D2278

Revision ID:

Item Name:

Step Leg

QC:

Start Date:

15/07/2009

Start Qty: 20.00

Req'd Qty: 20.00



Accept



Run

Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date: **Tooling:**

0.00

0.00

SPC (Y/N):

Date:

Date:

Start

Stop



Sequence ID/ **Work Center ID** **Operation** Description

Revision Nbr

Set Up/ **Run Hours** Draw Number

Draw Rev.

Plan Accept Qty Code

Reject Qty

Reject Insp. Stamp Number

Draw Nbr D2278

Rev F

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D2278 Deburr if necessary

:Dwg Rev:

·Prog Rev:

110

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

Quality Control

120

QC

QC8- Inspect parts - second check

Memo

0.00

Memo

0.00

Quality Control

Work Order ID 48090A

June 29, 2009 2:37:24 PM

Item ID:

D2278

Revision ID:

Item Name:

Step Leg

OC:

F

Start Date:

15/07/2009

Start Qty: 20.00

Required Date: 03/08/2009

Req'd Qty: 20.00



Accept



Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Draw

Rev.

Run

Start

Stop

Sequence ID/ Work Center ID

130

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Memo

Set Up/ **Run Hours** 0.00

0.00

Draw Number

Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

140

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

150

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00



Work Order ID 48090A

F

June 29, 2009 2:37:24 PM

Item ID:

D2278

Revision ID:

Item Name:

Step Leg

Start Date:

15/07/2009

Start Qty: 20.00

Req'd Qty: 20.00 **Required Date:** 03/08/2009



Accept



Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start



Stop



Sequence 1D/ **Work Center ID**

160

Quality Control

Operation Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/ **Run Hours**

0.00

0.00

Draw Number Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Qty:

20 Um:

Each

: STEP LEG

: D2278 : D2278 REV F

: 27/05/2009

: N/A

; F

Wednesday, 20/05/2009 1:51:10 PM

Melanie Fauteux

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 48090A

Type

S.O. No. :

Estimate Number

: 10353

: 20/05/2009

P.O. Number

This Issue

: NC Prsht Rev.

: //

First Issue : 47644A **Previous Run**

Written By

Checked & Approved By

Comment

: Est Rev:A

Est Rev:B Est Rev C

New Issue

Now 6061-T6 06-06-23 JLM New flat pattern 08.01.11 EC

05-11-07

JLM

: SMALL /MED FAB

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

6061-T6 .080 Sheet

1.0

M6061T6S080



Comment: Qty.: 1.0306 sf(s)/Unit Total: 20.6115 sf(s)

Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick

(M6061T62S.080) Identify as D2278

Batch: 112-0

FLOW WATER JET

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2278

Dwg Rev: Prog Rev:__

B9-6-24

2-Deburr if necessary

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

B96-24

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

3.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Page 1

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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									
					1				
			lo: PAR #: Fault Category: N					Date: _	
	Res	olution:	Disposition);	_ QA: N/C Clo	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STED	Description of NC		Corrective Action Section B Initial Action Description Sign 8		Verification		Approval	Approval
DAIL	SIEP	STEP Description of NC Section A		Action Description Chief Eng			Section C Chief Eng		QC Inspector

Date: Wednesday, 20/05/2009 1:51:10 PM User: Melanie Fauteux **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: STEP LEG Job Number: 48090A Part Number: D2278 Job Number: Seq. #: Description: **Machine Or Operation:** HAND FINISHING1 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 6.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 QC21 ON/W/O RELEASE 09/07/0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion (1 09.07.07

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES			-	
DATE STEP		PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	Part No: PAR #: Fault Category:				_ NCR: Yes	No DQ	A:	Date:	
	Resolution: Disposition:				_ QA: N/C C	closed:		Date: _	
NCR:		V	WORK ORE	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Section A Initial Action Descrip		Section B otion Sign &		cation on C	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date	?			
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,									

^{*} H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	4 8090A
Description: Leg	Part Number:	D2278
Inspection Dwg: D2278 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.354	+/-0.010	,354	*			
0.354	+/-0.010	354	8	-		
16.46	+/-0.030	16.46	8			
Ø0.128	+0.005/-0.000	.129	Ħ			
R0.354	+/-0.030	1354	A			
2.00	+/-0.030	9.10	8			
4.74	+/-0.030	4,740	bo			
8.46	+/-0.030	8,413	<u>}</u>			
0.213	+/-0.010	1913	¥			
0.750	+/-0.010	กุ49	4			
0.080 thick	+/-0.010	, OED	æ			

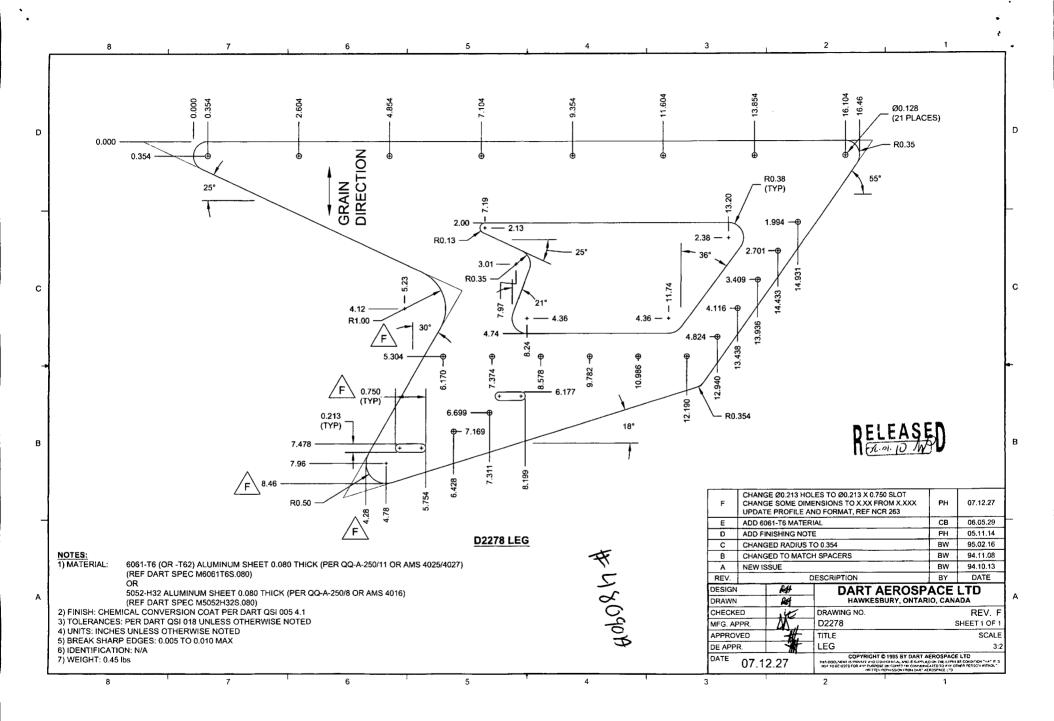
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 9-6-24	Date: 5/66/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.10.12	New Issue P/O D2582	KJ/JLM	
В	06.03.08	Dwg Rev. changed	KJ/JLM	
С	06.06.23	Dwg Rev. changed	KJ/JLM	
D	08.02.28	Dimensions updated per Dwg Rev F	KJ/DD	N.
			771	

Dart Aerospace Ltd

W/O:		WORK	WORK ORDER CHANGES							
- DATE	STEP	PROCEDURE CHANGE	В	By Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
,										
Part No	:	PAR #: Fault Category	NCR: `	Yes	No DQ	A:	Date: _			
	F	Resolution: Disposition:	QA: N/	C CIC	sed:		Date: _			

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B			Annroyal	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector



Dart A	\eros	space	Ltd
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W/O:			\M(C)	DV ODDED OUANO					
W/O:			WO	RK ORDER CHANG	iES		. ,		
DATE	STEP	. PR	. PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							<u>.</u>		:
						•			
									,
		PAR #:	Fault Category: NC			s No DQ	Date:	- 5	
	Re	esolution:	Disposition: QA			_ QA: N/C Closed: Date:			
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			ion B	Verifi	cation	Approval	Approval
	SILP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Section C		Chief Eng	QC Inspector